

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024746**Date Inspected:** 09-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: N/A

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

Blast shop #4, Segments 13AW, 13BW and 13CW

Caltrans and ABF have agreed to conduct visual and magnetic particle (MT) inspections of segment 13AW welds as part of a special reinspection program, reference NWIT 9431. This QA Inspector observed ABF performing MT inspections of SEG3013Y-274, 304, 276, 308, 278, 298, 312, 280, 316, 479, 480, 488, 318, 428, 400, 402, 404 and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. This QA Inspector performed random MT inspections of the following welds: SEG3013Y-282, 284, 288, 288, 291, 292, 270, 295, 272, 300 and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. ABF informed this QA Inspector that they have previously completed MT inspections of welds SEG3013Y-045~066, 197~220, 229, 230, 233, 234, 237, 238, 241~246, 249, 250, 257~260, 113, 115~117, 119~121, 123~125, 127~129, 131~140, 096~110, 068~072, 074~076, 078~080, 082~084, 086, 087, 090~092, 094, 095, 425, 426, 347, 349, 351, 353 and 355. ABF completed MT inspections of welds SEG3013E-004, 019, 024, 029, 034, SEG3013C-006, 013, 018, 024, 030, 036, 042. ABF rejected welds SEG3013E-004 and SEG3013C-013. This QA Inspector performed MT inspections of the following welds: SEG3013E-009, 014 SEG3013C-018, 024

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and items observed by this QA Inspector appeared to comply with AWS D1.5 MT requirements. This QA Inspector provided a turnover to dayshift personnel for tracking of these welds. For additional information on these inspections see this QA Inspector's TL6028 Magnetic Particle Test Report and the photograph below.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
